

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000643**Date Inspected:** 17-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China

CWI Name:	N/A			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** Plate Material**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Timothy McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following Plate Material Storage Yard:

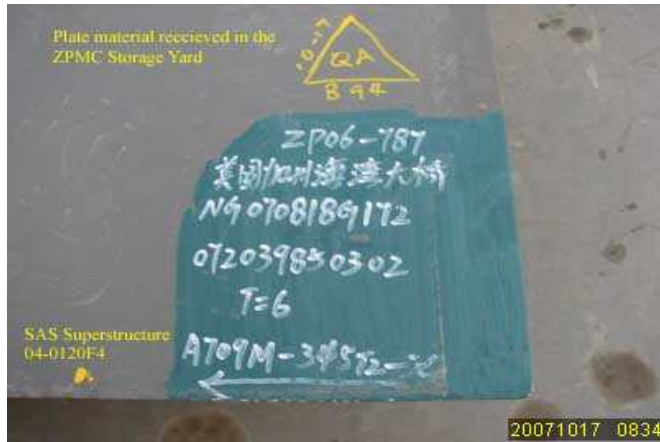
Quality Assurance (QA) Inspector Timothy McClendon recieved plate material list for batch #20, production list No. 1607 ~ 1671 from American Bridge/Fluor (ABF). QA Inspector Timothy McClendon went to the ZPMC material storage yard accompanied by ZPMC Quality Assurance Mr. Shen Xue Jun. QA Inspector Timothy McClendon observed a total of 26 out of 65 plates for batch #20. The plates were observed for their general condition and markings. Plate material thickness were 6mm and 14mm. The plates were designated as A709M-345T2-X and A709M-345T2-X-S. Plate material list for batch #20 was accompanied with material test reports (MTR's). The MTR's could not be reviewed on this date and will be reviewed at the earliest opportunity. QA Inspector Timothy McClendon assigned lot number B94-001-07 to the 26 Plates observed on this date.

Quality Assurance (QA) Inspector Timothy McClendon also recieved plate material list for batch #23, production list No. 1856 ~ 1914 from American Bridge/Fluor (ABF). QA Inspector Timothy McClendon went to the ZPMC material storage yard accompanied by ZPMC Quality Assurance Mr. Shen Xue Jun. QA Inspector Timothy McClendon observed a total of 49 out of 59 plates for batch #23. The plates were observed for their general condition and markings. Plate material thickness were 8mm through 20mm. The plates were designated as A709M-345T2-X, A709M-345F2-X, A709M-345T2-X-S and A709M-345T2. Plate material list for batch #23 was accompanied with material test reports (MTR's). The MTR's could not be reviewed on this date and will be reviewed at the earliest opportunity. QA Inspector assigned lot number B92-002-07 to the 49 Plates observed on

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this date.



Summary of Conversations:

QA Inspector Timothy McClendon questioned ZPMC Quality Assurance Mr. Shen Xue Jun concerns of plate No. 1669 on Batch #20 about what appeared to QA Inspector Timothy McClendon plate measuring 11mm instead of 14mm as stated on production list. Mr. Shen Xue Jun stated only the outer most edges, approximately 5 mm, were less than thickness stated on production list. Mr. Shen Xue Jun called Mr. Wu Yu Hua to perform measurements using UT thickness measuring gage model No. TT110 in order to determine plate thickness in areas other than the extreme edge of plate. It appeared to QA Inspector Timothy McClendon all readings taken by Mr. Wu Yu Hua exceeded 14mm which is stated on production list as the proper thickness for No. 1669 on Batch #20.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	McClendon, Timothy	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
